

Date: Wednesday, 11/03/2009 12:58:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 46429	
Estimate Number : 11175	
P.O. Number :	Part Number : D22825
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D2282 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 45385	Material :
Written By :	Due Date : 31/03/2009 Qty: 200 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM	
EstRev:B Now on Doosan Lathe 08-06-05 JLM	
Verified By:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R0750

304 SS Roundbar .750



Comment: Qty.: 0.1891 f(s)/Unit Total : 37.8126 f(s) M110912(x167) 15.69' 12.669' + 18.91'
 Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)
 Batch M110166X16parts 3.025' ml / 11/03/17

2.0

DOOSAN LATHE

DOOSAN LATHE



Comment: DOOSAN LATHE
 1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

ml / 11/03/17

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml / 11/03/17 (183)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28/09/03/17 (183)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Matthew Carl 1 9/13/10

(183)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 46429

Part Number: D22825

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/18 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46429
Description: Handle Tube		Part Number: D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.170	—			
R0.063	+/-0.010	R.063	—			
0.063	+/-0.010	.061	—			
0.125	+/-0.010	.124	—			
0.090 x 45°	+/-0.010	.084x45°	—			
R0.350	+0.010/-0.000	R.350	—			
0.158	+/-0.010	.156	—			
Ø0.386	+0.005/-0.000	Ø.390	—			
Ø0.700	+/-0.010	Ø.700	—			

Measured by: <i>mf</i>	Audited by: <i>SB</i>	Prototype Approval:	N/A
Date: 09/03/15	Date: 09/03/17	Date:	N/A

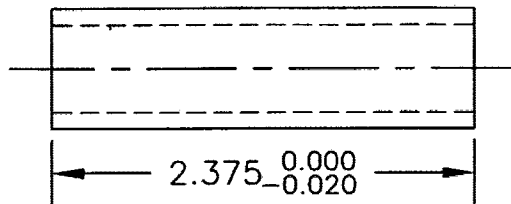
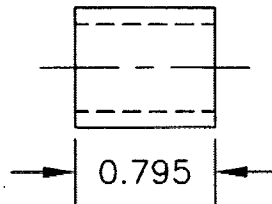
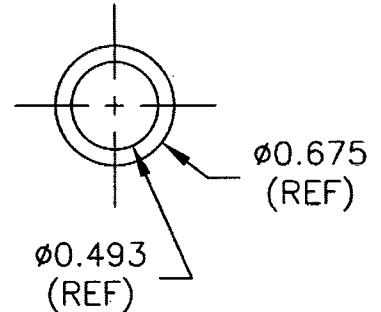
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	<i>[Signature]</i>

DART

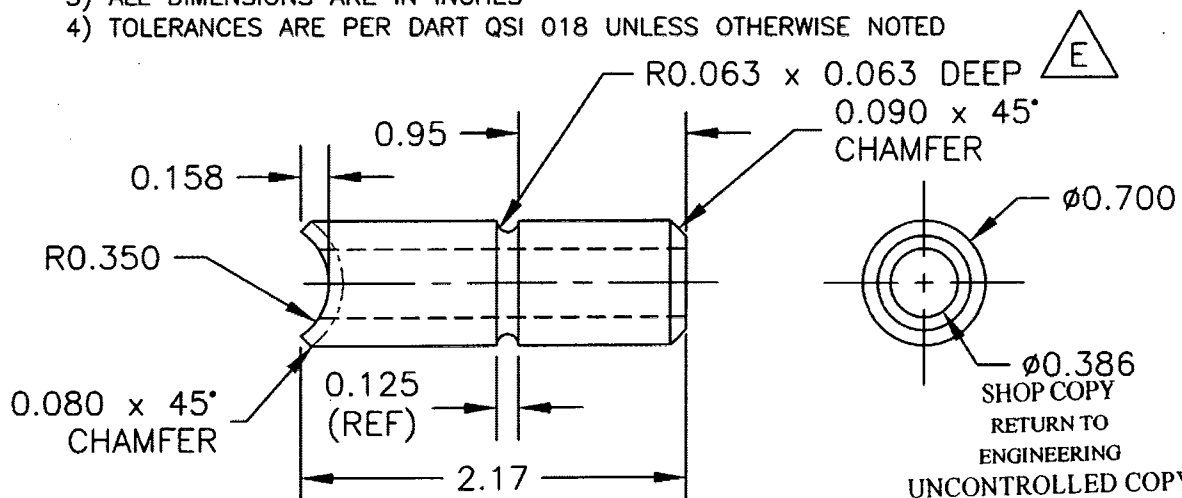
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

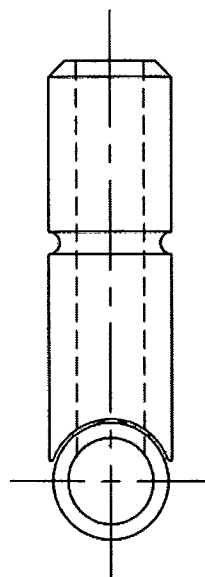
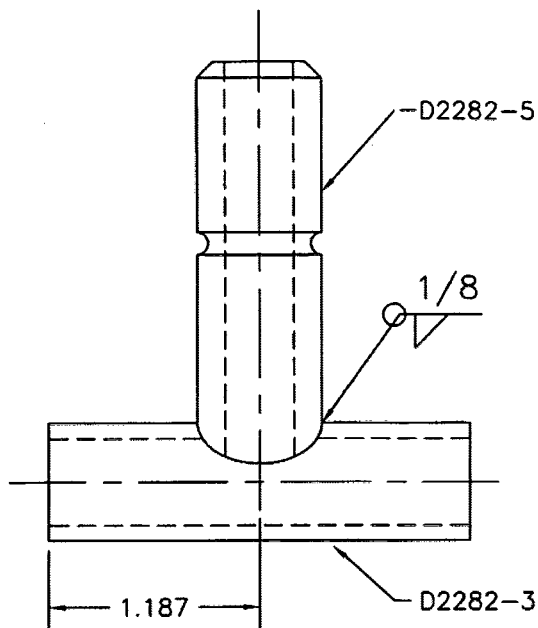
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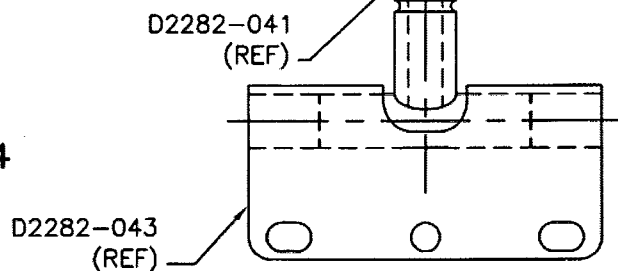


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

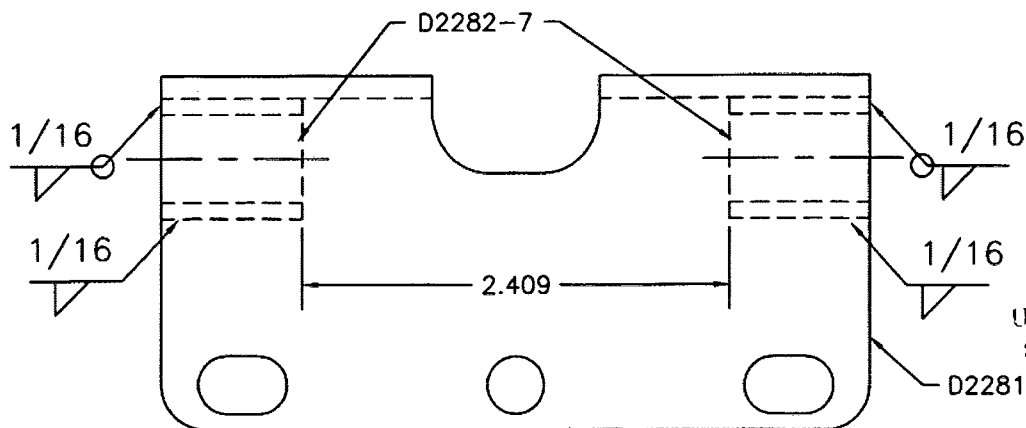


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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